

Work Order ID 154857

Thursday, December 22, 2016 11:04:13 AM

154857

Page 1

Item ID: D3901-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearbar Weldment

Start Date: 12/22/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/4/2017 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

DEC 22 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3901

F

100

0.00

100

Cold Saw

Hyd Mech

Memo

0.01

Cut blanks at 60.00"

EXTRA MATERIAL WILL BE REMOVE AT ASSY D3849-041

8 16-1-24

110

0.00

110

autoweld 1

Automated Welding 1

Memo

0.00

1- USE GRINDER TO CHAMFER END AS PER DWG . SEE "DETAIL D"

SEE NOTE 8 FOR SURFACE BUILDUP

2- WELD AS PER DWG AND QSI004 4.5

FOR AUTOMATED WELDING USE 8259 HARDCOAT

BATCH: 1354628 17-1-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval
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		OTHER : ☐			

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Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐	Part Moved ☐																
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐	Drawing ☐																
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐	Finish ☐																
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Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐	Turning Sequence ☐																
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____																					
Misidentified ☐		Past Due ☐																							

Work Order ID 154857***154857***

Page 3

Thursday, December 22, 2016 11:04:13 AM

Item ID: D3901-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearbar Weldment
Start Date: 12/22/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 1/4/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00					DAC 21 9-89	JAN 26 2017	
150									
QC	Memo	0.05							
Quality Control									



JAN 25 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Thursday, December 22, 2016 11:04:25 AM

Page 1

Work Order ID: 154857

154857

Parent Item: D3901-041

D3901-041

Parent Item Name: Wearbar Weldment

Start Date: 12/22/2016

Required Date: 1/4/2017

Start Qty: 3.00

Required Qty: 3.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No				f	509.8410		14.25158			

M304B0 250x0 500

304 BAR .250 x .500

a 1/7-24

Location

Loc Qty

Loc Code

MAT019

64.68

m136340

64.68

24.33

11.333' +13 24.33

WA002

445.161

134172

6

m133596

38.948

m133923

6.42

m135822

11.308

m136163

382.485

29.66

6.666' +13 19.66

71.09

(81.09)

M136553

(27.1)

27.1' +10

DQA: _____ Date: _____



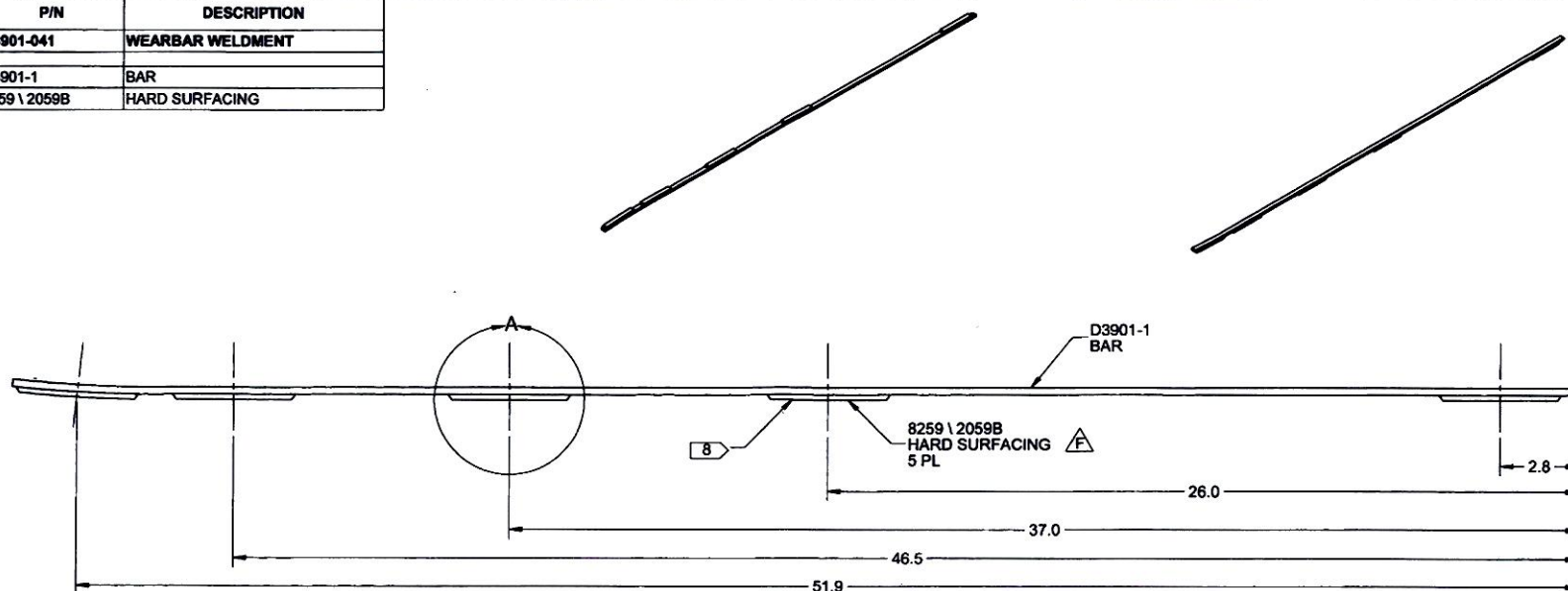
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

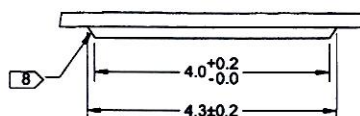
Work Order update only ☐

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		OTHER : ☐				

ITEM	QTY	P/N	DESCRIPTION
	X	D3901-041	WEARBAR WELDMENT
1	1	D3901-1	BAR
2	A/R	8259 \ 2059B	HARD SURFACING



A D3901-041 WEARBAR WELDMENT



DETAIL A
5 PL
(SCALE 2X)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.49 lbs
- 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING)
- 9) BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154857

DEC 22 2016

RELEASED
2016-06-16

REV.	DESCRIPTION	BY	DATE
F	SEE D3901-1F/3-F GROOVES REMOVED SEE REV E FOR FURTHER DETAILS. ADDED D3901-041/043-045. 1B7 ADDED DETAIL A; 3A7 ADDED DETAIL C; 4B4 ADDED DETAIL D; 5B5 ADDED DETAIL E 6B4 ADDED DETAIL F. WELDING SLOTS REMOVED. NOTE 8 RE-WRITTEN FOR NEW PROCESS. 4D4 DIM WAS 54.2, 5D4 DIM WAS 66.87.	AJS	16.01.04
E	CHANGE LOCATION OF END POCKETS ON -1/3-5 (ZN B1-2, D6-2, B7-3, B2-3, D1-4, D7-4).	DC	12.08.23
D	CHANGE LOCATION OF END POCKETS ON -1/3-5 (ZN D1-2, D6-2, B7-3, B2-3, D1-4, D8-4). SPLIT POCKETS INTO TWO SEPARATE POCKETS (ZN A2-2). ADD POCKET TO -1 (ZN D6-2).	DC	12.08.21
C	0.25 WAS 0.20 AND 0.130 WAS 0.080 (ZN B2-2, B1-2, B1-3, D8-4); ADD MISSING DIMENSIONS (ZN C5-3); ADD D3901-1F/3-F FLAT PATTERN	RF	12.01.24
B	REMOVE Ø0.188 HOLES FROM D3901-1/3-5; 62.12 WAS 62.61 (ZN C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. F
MFG. APPR.	DD	D3901	SHEET 1 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BAR	NTS
DATE	16.01.04	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

DQA: _____ Date: _____



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